

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018192**Date Inspected:** 16-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG TRIAL ASSEMBLY YARD

**WELDING:****Segment 11AW**

This QA Inspector observed ZPMC qualified welding personnel identified as 044779 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG065A-002; located On Orthotropic Box Girder (OBG) Side Plate to Side Plate Longitudinal Splice CJP Weld. The Welding Repair Report (WRR) was B-WR16838. ZPMC QC is identified as Mr. Zhang Qiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-345-SMAW 4G (4F) FCM-Repair-1. See attached photo for further details.

**Segment 11AE**

# WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA082-005; located On Orthotropic Box Girder (OBG) Side Plate to Edge Plate CJP Weld. The Welding Repair Report (WRR) was B-WR17064. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-345-SMAW 4G (4F) FCM-Repair-1. See attached photo for further details.

## Segment 11BE

This QA Inspector observed ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA084-002; located On Orthotropic Box Girder (OBG) Side Plate to Edge Plate CJP Weld. The Welding Repair Report (WRR) was B-WR17091. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-345-SMAW 4G (4F) FCM-Repair-1.

## Segment 11EE

This QA Inspector observed ZPMC qualified welding personnel identified as 047353 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG074B-005; located On Orthotropic Box Girder (OBG) Floor Beam to Longitudinal Diaphragm CJP Weld; ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-2232-TC-U4b-F.

## Segment 11DW

This QA Inspector observed ZPMC qualified welding personnel identified as 040609 perform Flux Core Arc Welding (FCAW), weld joint identified as SP785-001-027; located On Orthotropic Box Girder (OBG) Side Plate T-Rib Hold Back Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.



## Summary of Conversations:

No significant conversations were reported on this date.

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## WELDING INSPECTION REPORT

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhune,Manoj
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art
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QA Reviewer
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